

Date: Wednesday, 1/24/2007 4:45:23 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HIGH AFT X-TUBE 412			
Job Number	: 30425						
Estimate Number	: 10559						
P.O. Number	: N/A		Part Number	: D412664203			
This Issue	: 1/24/2007	S.O. No. : N/A	Drawing Number	: D412-664-243 REV C			
Prsht Rev.	: NC		Project Number	: N/A			
First Issue	: N/A		Drawing Revision	: C			
Previous Run	: 30424		Material	: N/A			
Written By	: JF		Due Date	: 2/28/2007			
Checked & Approved By	: ST 07.01.25			Qty:	1	Um:	Each
Comment	Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM est rev G 06.12.08 per ECN 886 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL  Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D412-664-203 CHG 005
2.0	D6009129	Crosstube Material 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D6009-129 Crosstube <u>B26548</u> Check OD = 3.500"; ID = 2.250"
3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE 
		Comment: MORI SEIKI CNC LATHE LARGE 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166 2-Turn first side as per Folio FA166 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.
4.0	QC1	INSPECT ALL DIM TO DIM SHEET 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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5.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3- Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243
engrave on outside of tube)

Inside of Cuff(Donot

mk 07/02/03

6.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

mk 07/02/03

7.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 07-02-05

8.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

DP / mk 07-02-07

1-Polish entire outside surface of crosstube

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP7-2-7

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DP / mk 07-02-07

11.0 QC3/5 INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

DP7-2-7

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:	Machine Or Operation:	Description :
12.0	BENDING	BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010 EL125 7-3-7

13.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

10/03/08 (1)

14.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

JD 7-3-8

15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-3-8

16.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

17.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

18.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 3440 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

10/03/280

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

C 20703/30 ①

20.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

21.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

} M 20704-04-16

2-Paint outside crosstube with White Imron as per QSI 005 4.2

22.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

23.0 D2856600 Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty	Part number	Description	Batch
2	D2856-600(Cut to 10.090")	Abrasion Strip	26650 ml 0707 18

24.0 D28961 Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2896-1	Support	30200 F1 07-07-19

25.0 D31891 Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
2	D3189-1	Chafing Shield	30513 0707 18 M

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 30425		Part Number: D412664203
Job Number:		
Seq. #:	Machine Or Operation:	Description :
26.0	MS2192028	Clamp(per MIL-DTL-8783C) 
		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick: Qty Part number Description Batch		
4 MS21920-28 Clamp 103896		ml 07 07 18
27.0	MS2192032	clamp(per MIL-DTL-8783C) 
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
clamp(per MIL-DTL-8783C) batch: 102931		BT 07 07 19
28.0	D2732	Rubber Extrusion 
		
Comment: Qty.: 1.0290 f(s)/Unit Total : 1.0290 f(s)		
Rubber Extrusion		
Cut qty 2 5.80" long		
qty part # description batch		
2 D2732-058 rubber cushion 30894		ml 07 07 22
29.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1 
		
Comment: LANDING GEAR RESOURCE 1		
Assemble as per Dwg D412-664-203		
Instal support with magnobond 6398 per dwg D412-664-203, cure for 12hrs before packaging.		
Time & date of application: 2:15 07.07.19		
30.0	QC5	INSPECT WORK TO CURRENT STEP 
		 PFO →
Comment: INSPECT WORK TO CURRENT STEP		
31.0	PACKAGING 1	PACKAGING RESOURCE #1 
		
Comment: PACKAGING RESOURCE #1		
Pick Packing Kit		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/24	11 30.0	Chomfering shield was found with a Dent/kink. was damaged during assembly	QSI042	<ul style="list-style-type: none"> - Remove damaged chomfering shield - clean off left over solder flux - Reinstall new chomfering shield. 	EP 07/07/24	EP 07/07/24	QSI042	EP 07/07/24
				- B# 32513				

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Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30425

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
32.0	AN640A	Bolt
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Bolt	
	Batch: M103177 ✓	
33.0	AN641A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Bolt	
	Batch: M100743 ✓	
34.0	AN960JD616	Washer
	Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)	
	Washer	
	Batch: M103641 ✓	
35.0	MS21042L6	Nut
	Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)	
	Nut	
	Batch: M101660 ✓	
36.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS	
37.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Identify and pack for shipping as per PPP D412-664-203	
	*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date	

	Time & date of packaging: PPP 32928	
	Location: 7/7/2022	
	PPP Rev: 12:30 AM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1/24/07/06

Job Completion



u 0.07.25

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30425
Description: Crosstube Assembly (412 High Aft)	Part Number:	D412-664-243
Inspection Dwg: D412-664-243 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

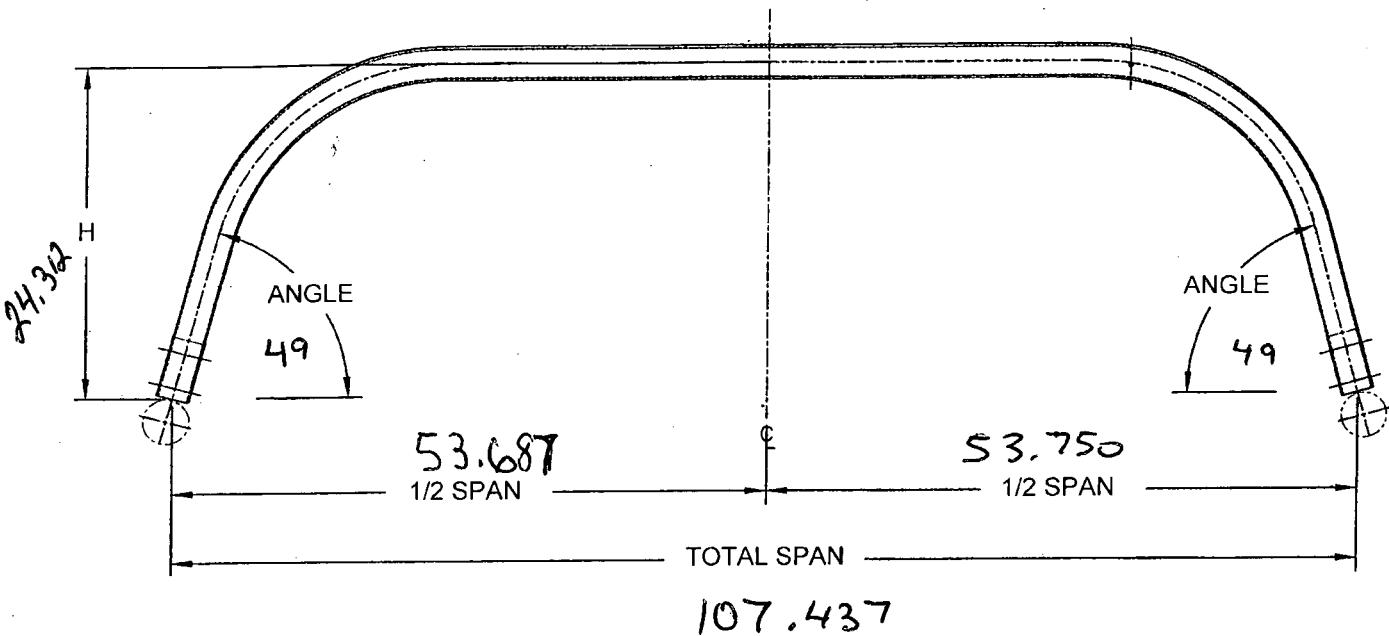
First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.689	—		
	2.748	+0.005/-0.000	2.753	—		
	2.884	+0.005/-0.000	2.889	—		
	3.019	+0.005/-0.000	3.024	—		
	3.163	+0.005/-0.000	3.168	—		
	3.308	+0.005/-0.000	3.310	—		
	3.429	+0.005/-0.000	3.432	—		
	2.990	+0.005/-0.000	2.991	—		
	2.618	+0.005/-0.000	2.622	—		
	0.200	+/-0.010	0.206	—		
	R0.063	+/-0.010	R0.063	—		
	R0.500	+/-0.010	R0.500	—		
	4.971	+/-0.001	4.971	—		
SIDE B	2.684	+0.005/-0.000	2.689	—		
	2.748	+0.005/-0.000	2.753	—		
	2.884	+0.005/-0.000	2.889	—		
	3.019	+0.005/-0.000	3.024	—		
	3.163	+0.005/-0.000	3.168	—		
	3.308	+0.005/-0.000	3.313	—		
	3.429	+0.005/-0.000	3.434	—		
	2.990	+0.005/-0.000	2.991	—		
	2.618	+0.005/-0.000	2.622	—		
	0.200	+/-0.010	0.206	—		
	R0.063	+/-0.010	R0.063	—		
	R0.500	+/-0.010	R0.500	—		
	4.971	+/-0.001	4.971	—		
	124.09	+/-0.020	124.090	—		

Measured by:	TMK	Audited by:	SD	Prototype Approval:	N/A
Date:	07/02/03	Date:	07.02.03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	JK JLM

Crosstube Bend Dimension Sheet



PART NUMBER: A412 664 203

BATCH NUMBER: 30425

DRAWING: A412 664 243 REVISION: C

H: 24.37

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50°

QC 15: M

DATE: 07/03/08

QTY: 1

Fit in tube jig

DART

DESIGN <i>PH</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D412-664-243	REV. C SHEET 1 OF 3
DATE 06.10.27		TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE NTS
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	

RELEASED

ab. 4-28-*MM*PARTS LIST:

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D2732-058	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-32	CLAMP
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

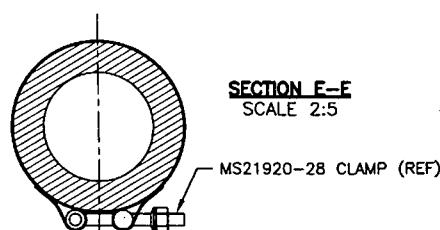
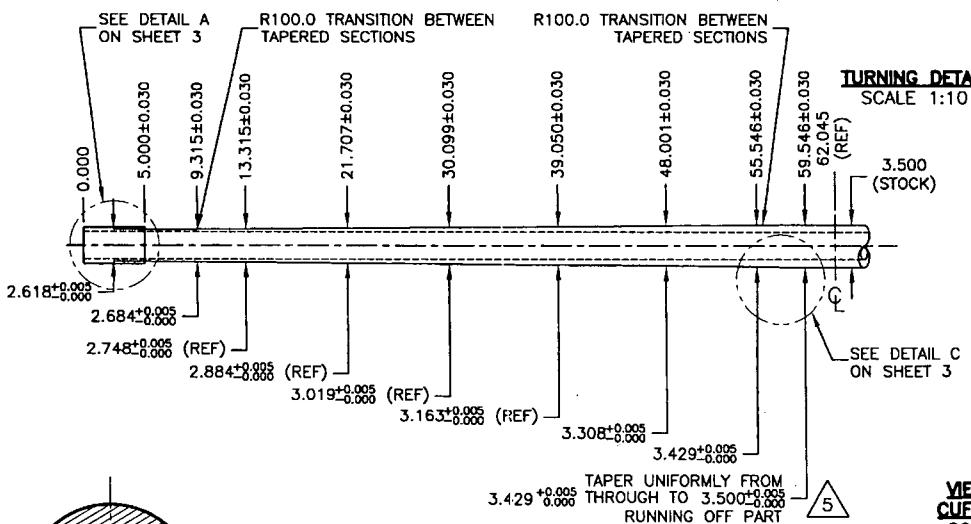
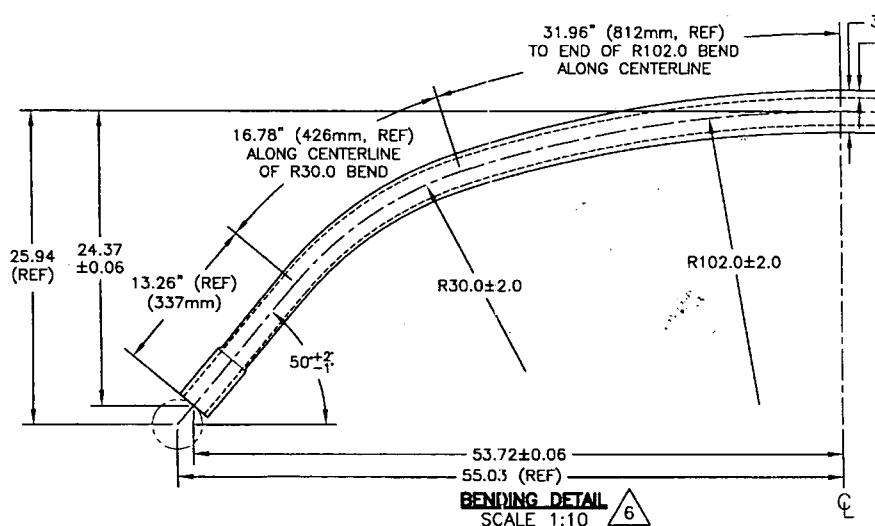
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTERSHOP COPY INSTALLATION AND PRIOR PACKAGING.
- 12) INSTALL MS21920-32 CLAMPS WITH D2732-058 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB.

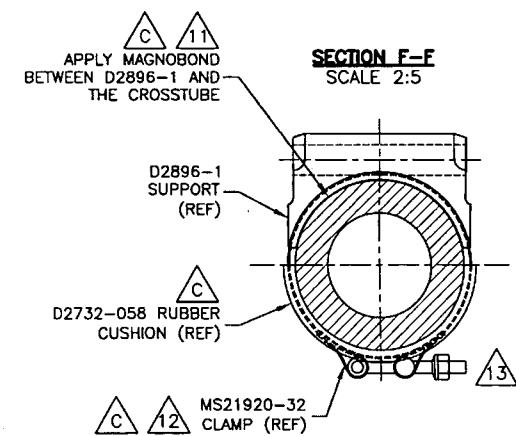
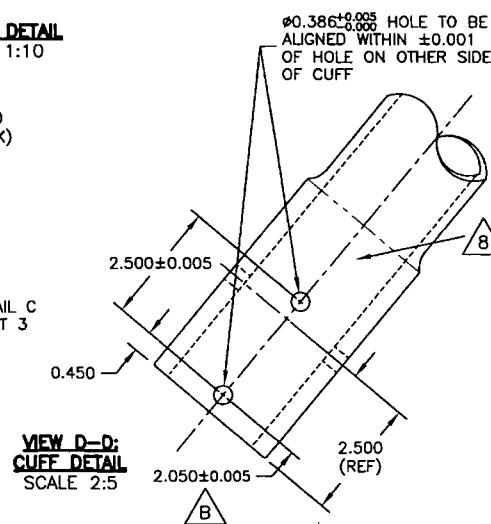
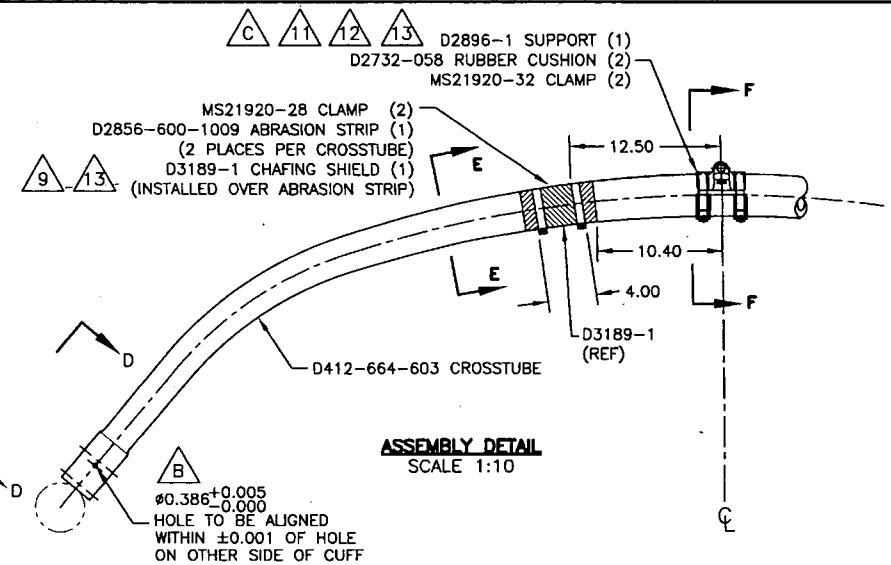
RETURN TO
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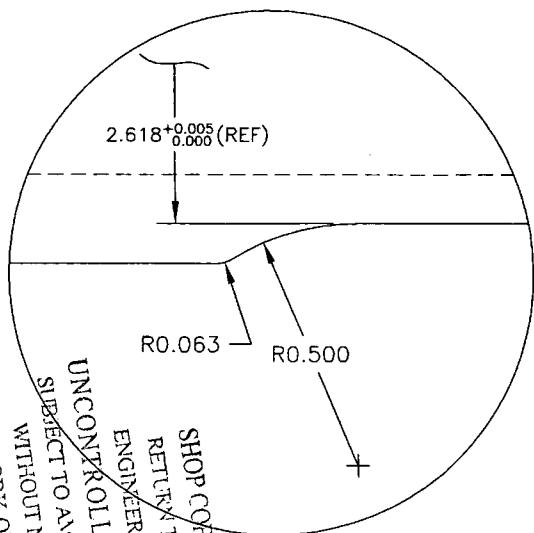
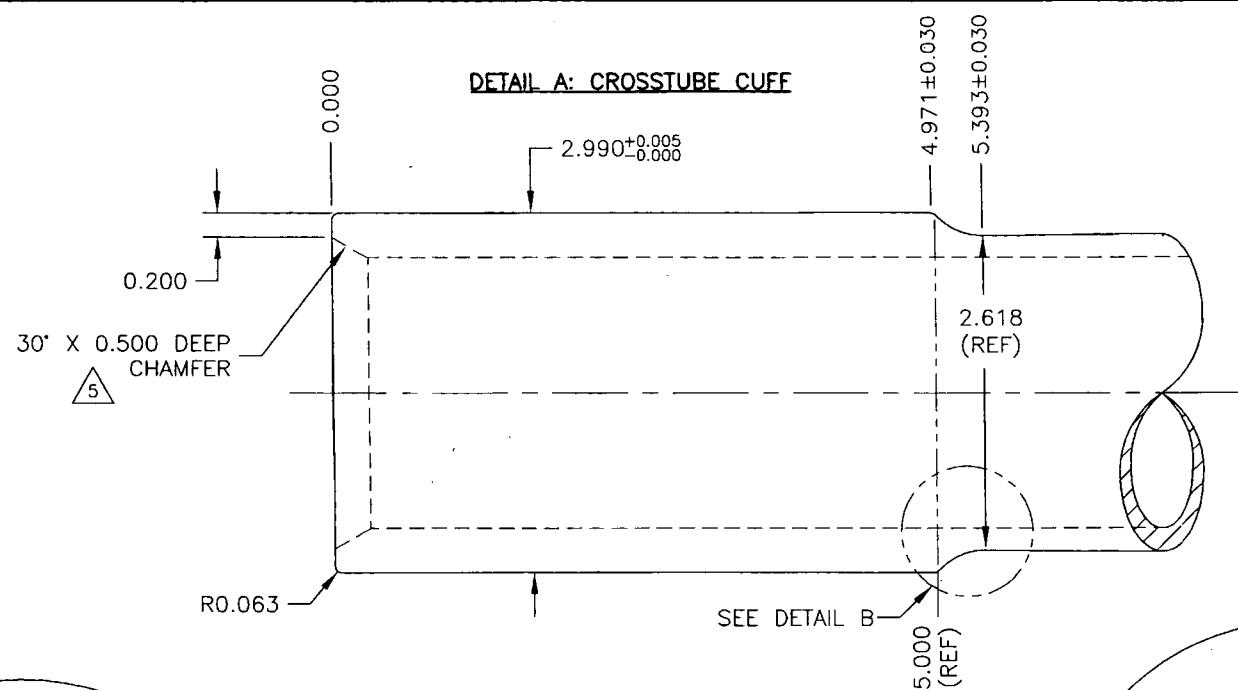


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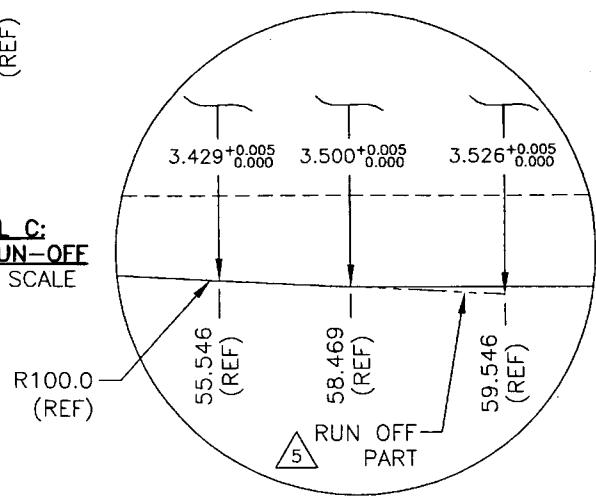


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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	CHECKED PH	APPROVED SH	DRAWING NO.	D412-664-243	REV. C
			DATE	06.10.27	SHEET 2 OF 3
			TITLE	CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE 1:10

RELEASED
06.11.28



**DETAIL C:
TAPER RUN-OFF**
NOT TO SCALE



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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HANDBURY, ONTARIO, CANADA
PH	BS	PH	DRAWING NO. D412-664-243
CHECKED PH	APPROVED	REV. C	SHEET 3 OF 3
DATE 06.10.27	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE 1:1	

NO. 30425
WORK ORDER
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. № 36061

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of seven (7) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (2) P/N D412-664-145 S/N's B31137 & B31138
Qty. (1) P/N D206-667-103 S/N B30428
Qty. (2) P/N D412-664-203 S/N's B30427 & B30425
Qty. (2) P/N D206-667-101 S/N's B30439 & B30437

 RADIOGRAPHY ULTRASONIC PENETRANT MAGNETIC PARTICLE EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on seven (7) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

Seven (7) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

DATE March 29, 2007

INSPECTED BY: 

INSPECTION STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

3440

ADDRESS:

CONTACT NAME:

LABOUR	@	\$
MATERIALS	@	
TRAVEL EXPENSES	@	GST
HOTEL EXPENSES	@	PST

INVOICE NO.

TOTAL \$